

Saltfork Craftsmen Artist-Blacksmith Association

October 2021



**Young Craftsmen Learning Forging at the Pioneer Days Demo
Cheyenne, OK September 11, 2021**

**The 2021 Saltfork Conference is here!
Register now if you haven't already. The best way to register is from the Saltfork Craftsmen website.
It's FAST and EASY!
(More Information on Page 8)**

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Artist-Blacksmith Association
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Editor's Notes:

2021 Conference Updates:

The 2021 Conference is this month. If you are reading this before the conference you are likely reading it online. If you are reading the hard copy, the Conference is either underway or already past. It seems that the advent of covid has left lasting effects on production and mailing times that may be here to stay for some time. And this year, some of the Conference details have been a bit of a moving target which has only added some more delays in going to press. I will apologize if you are getting your hard copy newsletters in a "less than timely" manner, but there really isn't too much that I can implement to speed them up yet.

There is a last minute Conference update. Lyle Wynn has just taken a new job in Texas and cannot attend the Conference. However, Lyle sends his highest recommendation for Palmer Robbins who will take his place as demonstrator for the Tools-to-Make-Tools curriculum. Palmer has been teaching the course with Lyle and has been keeping their shop running while Lyle is absent working as I understand it. Lyle says he is a great demonstrator which is a pretty solid reference.

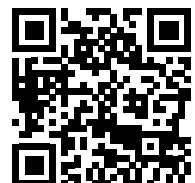
If there are any important updates prior to the Conference, they will be by supplemental communications including member e-mails, the Saltfork website and Facebook. We hope to see you there!

-Russell Bartling, Editor

The Saltfork Craftsmen Artist-Blacksmith Association, a non-profit organization. Our purposes are the sharing of knowledge, education and to promote a more general appreciation of the fine craftsmanship everywhere. We are a chapter of the Artist-Blacksmith Association of North America.

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Visit our Saltfork Craftsmen Website:
www.saltforkcraftsmen.org



President's Notes:

Hello Everyone,

It looks like fall is here and it's cooler while working in the shop. And lately I don't have as hard of a time working when it is cooler.

Thanks to everyone who has demonstrated at different events in the state recently. It promotes our club and is helping to get everyone active again.

We have been working on this year's conference and I hope it is a good one. I look forward to seeing everyone. I hope everyone who can will bring tools for the toolbox and items for iron-in-the-hat and the auction. This year has been different for everyone and planning has been a challenge.



And don't forget about the Peoples' Choice Gallery. For new members, that is something you have made and want to show off. We have had some really good projects in the past. Some of them will make the wheels turn in your head wondering how the project was done. *(All kinds of projects are welcome from beginner to expert. And you can never predict how your project will inspire someone else. Also, there are two categories where the projects that are displayed can win awards by popular vote. You can see more detail on page 9 of this newsletter - Editor)*

Enjoy the good forging weather. I am hoping we get some rain where we need it. It is getting really dry in the western part of the state.

Change your quench tank water every once in awhile. You will be surprised what you find if you had other people working in your shop!

Thanks, - Mandell

All Regional Meetings are Free to Attend and are Always Open to Any Member or Guest...

New to Saltfork or just want to check out Blacksmithing but don't know where to start? These meetings are a great place for new members or guests who just want to see what it is all about to come network with like-minded people. If you want some pointers on how to get started, there is always someone happy to help get you started hammering. And guests are always welcomed.

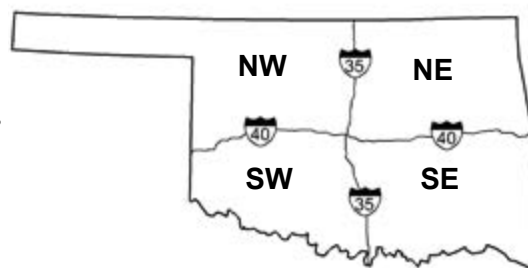
Want to host a meeting? The meeting hosting form can be found on the last page along with membership application form. If you want to host a meeting in any area, please fill out one of the host forms on the website under the calendar section or in the newsletter and e-mail the information or mail the hard copy form in as soon as possible. If you mail a form, please call or e-mail to verify that it is received. E-mail is the most convenient for me, but you can also phone in the information if you prefer. The sooner the meeting is scheduled, the more time there is to get the word out to potential attendees. -Russell Bartling 918-633-0234 or rbartling@ionet.net

What's My Region?

The four main regions are currently defined within the state by being separated by I35 and I40. (For example, the NW region is anything north of I40 and west of I35.)

All meetings are encouraged. These boundary definitions and regional meeting dates are a suggested framework to facilitate orderly meeting scheduling, planning and promotion with a minimum of overlaps and a maximum exposure to the greatest number of members. Not all meetings fit precisely within a rigid boundary definition and members in an area may want to hold meetings on a date that doesn't match their physical region or at a location other than their own region. This may be especially true in the center of state for areas that are close to the I35 and I40 boundary crossing. Special events such as shows, fairs, etc. may also dictate adjustments to the meeting dates within a region.

SCABA Regions



The regions are meant to be a simplification and clarification to the regional boundaries rather than a rigid restriction to any meeting scenario. ***Saltfork members all belong to one club.*** Regional boundaries are not intended to imply division within the club, but are intended to help spread distribution and promote monthly meetings.

Safety

Blacksmithing can be an inherently dangerous exercise. There is no substitute for personal responsibility and common sense and no list of safety rules can adequately cover every situation. Every person who attends a meeting, demonstration or event sponsored by the Saltfork Craftsmen Artist Blacksmith Association (SCABA) or its members does so at their own risk and assumes all responsibility for their own safety needs. The SCABA organization, its officers, members, demonstrators, volunteers and guests disclaim any responsibility for any damages, injuries, or destruction of property resulting from the use of any information or methods published or distributed by SCABA or demonstrated at workshops, meetings, conferences or other events. SCABA recommends proper attire and safety gear and standard shop safety procedures appropriate for blacksmithing and shop work during any event where blacksmithing and other related methods are involved. Safety attire includes, but is not limited to, appropriate clothing, eyewear, hearing protection, gloves, and face shields when appropriate. It is every individual's responsibility to provide for their own safety, to determine what safety gear is appropriate for each situation and to provide, maintain and use that gear as appropriate for each individual situation.

2021 Workshop Schedule

The Board of Directors and the Workshop Coordinator are always looking for feedback from members on what workshops you would like to see from fundamentals to advanced. Please let them know! If there is group interest in a specific workshop topic, they will work hard to try to make it happen.

BLACKSMITH BEGINNERS' WORKSHOP

WHEN: Saturday, 13 November, 8 A.M.
WHERE: Muldrow City Park

Saltfork Craftsmen will be hosting a beginners Blacksmithing workshop on Saturday, November 13th, beginning at 8 A.M. and running until complete. (About 3 P.M) All tools and materials will be provided. Projects will include, an S-hook, a forged leaf keychain, and a hot cut chisel. We will be covering the basic blacksmithing skills of tapering, drawing, scroll work, and heat treating. A hot lunch will be provided. Slots are limited so please reserve yours early. Cost for the course is \$40 per person. Minors under 16 must be accompanied by a responsible adult.

To make reservations, or for questions, please contact **Bradley Nance @ 918-774-4291**, or email at Bradley.nance@cnent.com

(Please note that due to insurance requirements, all participants must be members of Saltfork Craftsmen. Membership is \$ 30 per year, and covers all family members. Membership fees are payable at the time of the course or by contacting Teresa Gabrish, at Treasurer@saltforkcraftsmen.org)

Have an idea for a workshop or class? If you have an idea for a workshop that you would like to attend (or teach), please let the workshop coordinator know so that details for time and place can be worked out.

We have two workshop coordinators:

Western Areas: Mandell Greteman is the SCABA Workshop Coordinator.
Contact Mandell at 580-515-1292.

Eastern Areas: Brad Nance is the SCABA Workshop Coordinator.
Contact Brad at 918-774-4291.

Coronavirus Safety Concerns/Event Cancellations:

With recent developments concerning COVID19, a large number of blacksmithing related events have been canceled for safety reasons. It will be more important than ever to stay posted with websites, social media, etc. and to double check before assuming events will be held.

-Russell Bartling, Editor

2021 REGIONAL MEETING SCHEDULE

NE Region (1st Sat)	SE Region (2nd Sat)	SW Region (3rd Sat)	NW Region (4th Sat)
Jan 2nd (Open)	Jan 9th (Open)	Jan 16th (Open)	Jan 23rd (Open)
Feb 6th (Open)	Feb 13th (Open)	Feb 20th (Open)	Feb 27th (Doug Hyde)
Mar 6th (Open)	Mar 13th (Open)	Mar 20th (Open)	Mar 27th (Mandell Greteman)
Apr 3rd (Don Garner)	Apr 10th (Diana Simon)	Apr 17th (Open)	Apr 24th (SCABA Picnic!)
May 1st (Open)	May 8th (Open)	May 15th (Open)	May 22nd (Rory Kirk)
Jun 5th (Open)	Jun 12th (Open)	Jun 19th (Open)	Jun 26th (Everett Timmons)
Jul 3rd (Matthew (Ragnar) Crowson)	Jul 10th (Open)	Jul 17th (Open)	Jul 24th (Open)
Aug 7th (Diana Simon)	Aug 14th (Open)	Aug 21st (Open)	Aug 28th (Open)
Sep 4th (Tracy Cowart)	Sep 11th (Open)	Sep 18th (JJ McGill)	Sep 25th (Ron LehenBauer as Host - Don Garner as Contact Person)
Oct 2nd (Open)	Oct 9th (Conference Setup)	Oct 16th (Conference Weekend)	Oct 23rd (Rory Kirk)
Nov 6th (Diana Simon)	Nov 13th (Open)	Nov 20th (Open)	Nov 27th (Open)
Dec 4th (Open)	Dec 11th (Open)	Dec 18th (Open)	Dec 25th (Christmas Day)

2021 Fifth Saturdays:

January 30th (Open)

May 29 (Boy Scout Meeting at Murray County Antique Tractor Show Grounds.)

July 31st (Beginner Blacksmith Workshop - Elk City)

October 30th (Open)

October 2021

NE Regional Meeting October 2nd: (Open.)

SE Regional Meeting October 9th: Is reserved for the Pre-Conference Set Up Work Day in Sulphur, OK. Please come help get the site ready for the Conference if you can!

SW Regional Meeting October 16th: **Conference Weekend!!**

NW Regional Meeting October 23rd: Will be hosted by Rory Kirk at the Route 66 Museum Blacksmith Shop in Elk City.

Trade item is a forged candle holder.

Lunch will be provided but please bring a side dish or dessert to help out.

Contact Rory Kirk at 580-497-6426 if you have questions.

November 2021

NE Regional Meeting Nov 6th: Will be hosted by Diana Simon and the Cherokee Strip Historical Society at the new Blacksmith Museum and Shop. 2617 W. Fir Ave, Perry, OK 73077. The shop is located approximately 1/4 mile east of Exit 186 from I-35 on north side of the road (Hwy 64 or Fir St.)

The trade item is whatever you want to bring or make.

The meeting is planned to start at 9:00 AM. Lunch will be provided.

Contact Diana Simon at 580-572-8290 or dsimon@gmail.com if you have questions.

SE Regional Meeting Nov 13th: Open.

SW Regional Meeting Nov 20th: Open.

NW Regional Meeting Nov 27th: Open.



Anvil Quilt Drawing

This one of a kind anvil quilt provided by Bill and Angela Phillips will be raffled at the 2021 Saltfork Conference.

You can obtain tickets at the Conference for \$2.00 each. If you will not be at the conference but still would like tickets, contact the Secretary.

Drawing will be held Saturday evening.



2021 Saltfork Conference



October 16th and 17th
Sulphur, OK

The Best Way to Register for the Conference is Online Through the Saltfork Craftsmen Website

Online registration is fast, safe and easy.

You do NOT have to have a Paypal account to register online! Watch for additional information by e-mail from Eric Jergensen or check the Saltfork Website. Website registration has extra benefits!
(Registration in-person at the conference will also be available.)

Location:

Murray County Antique Tractor Association Show Grounds
7 miles north of Sulphur on Hwy 177, 3/4 mile east on Tractor Road
Sulphur, OK

Family Classes

Family Classes for the Conference are to be determined. Complete information on the Family Classes will be provided in the August newsletter. Stay tuned for more details.

Conference Workshops October 18, 19 and 20th:

Workshops with the demonstrators - Brent Bailey and Lyle Wynn - are planned after the conference. The format will be similar to previous years. Each demonstrator will conduct a 10 student workshop over three days following the conference (Monday through Wednesday). The workshops will run concurrently so you will only be able to register with one instructor. This is an amazing opportunity to receive hands on instruction with instructors of this caliber.

Participants must provide their own (or arrange to borrow) safety gear and forging stations including anvil, forge, vice, and basic forging tools such as hammers, tongs, chisels, and punches etc. Specific tooling requirements for any tools that will not be provided will be made available before the workshops.

Exact details and cost for the workshops are being finalized with the demonstrators and will be announced. Expected approximate cost for each workshop will be around \$350 per student including meals. There may also be an additional material cost depending on final workshop arrangements.

Registration information and additional details will be announced. Watch for member e-mail updates and stay tuned to the Saltfork Craftsmen Website and Facebook pages.

2021 SCABA Annual Conference

Peoples' Choice Awards and General Gallery

Two Categories:

We will once again have **two categories**, one will be for work done using “**Traditional**” methods and the other will be “**Open**,” meaning open to use any and all methods of the artist’s choosing.

The intent here is to separate work that is done with methods generally considered traditional to blacksmithing, such as forge welding, joinery, punching, upsetting, drawing out, etc. from more modern methods such as arc/mig/gas welding, stock removal grinding, etc. These “modern” methods have become, in many cases, much faster and easier to use than the traditional methods due to modern machines and equipment. This separation is an attempt to allow a potential gallery submission to be judged against other work on a more equal footing than is practical with a single overall category.

If there are any issues that come up, the Board of Directors will make a judgment on how to place the piece in the Gallery. Mostly, any benefit of the doubt will go to the entrant.

General Gallery:

We would also like to see a general gallery of work from all levels on display. It does not have to be all new work or work submitted for the People’s Choice voting. It can be for sale or just for display. But we would like to have anything you are proud of making or that you find inspirational to be on display. Even work by beginners is often an inspiration so please don’t hold back thinking your work is “not good enough.” Keep in mind, there will be visitors that have never even forged an S-Hook or a leaf key chain. Any work probably has something to teach and inspire others. Please consider bringing your items to display! - *Editor*

2021 SCABA Conference RV Reservations:

It is not too early to make reservations if you plan on camping on site and need an RV hookup. Primitive camping is also available with access to clean toilets and showers if you prefer primitive camping. RV hookups are available for \$15 per RV per night (to the Tractor Club) for electric only service. Spots are already being reserved so contact J. J. McGill as soon as possible if you would like to make a reservation.

Contact J. J. McGill at 580-369-1042 or jjmcgill88@yahoo.com

2021 SCABA Conference Tool Box

Brad Nance is constructing this year’s toolbox.

But we need tool donations to fill it!

Any donated tool is greatly appreciated, as proceeds from this drawing benefit the Saltfork club as a whole, but hand made tools are the most appreciated by those interested in winning the box. Either way, the winner of the tool box drawing will have a nice collection of usable tools that they will be proud to own.

Tickets for a chance to win the Conference Toolbox will be available up until the drawing at the auction on Saturday night. If you will not be able to attend the conference and want a chance to win the tool box while supporting the club, tickets may be purchased from the Secretary. Tickets are \$2.00 each.

Iron in the Hat

Gerald Franklin

Many of our newer members were confused at last year's conference as to what this "Iron in the Hat" (IITH) thing was all about. Since I have been appointed as the IITH coordinator for the conference, I guess it's one of my duties to explain the tradition and how we observe it at our conferences.

The Iron in the Hat activity is an old blacksmithing tradition (exactly how old is anybody's guess) that makes a little money for the sponsoring organization and provides an outlet for some of the things that an individual smith may not need anymore but another smith may "covet". Basically it's a raffle of sorts where items are donated, tickets are sold and drawn and the items then change owners.

Here's how it works at the Saltfork Conference. Members, merchants, and just good people donate items. We put the items out for display with a paper sack beside each item. Tickets are sold and buyers put one or more tickets into a sack corresponding to an item they are interested in. If you would really like to have a particular item, put several tickets into the sack. At a particular time a winning ticket is drawn from a sack and then taped to the item. Buyers then come by and check the tickets to see if they are a lucky winner. This is pretty simple, and there will be more information posted at the conference as to price, frequency of drawings, etc.

So, what makes it work? The short answer is "item donors and ticket buyers". You can help in both ways. Bring stuff to the conference to donate to the IITH table. This may be a piece of tool steel that you don't need, an extra pair of tongs (I know, NOBODY has an extra pair of tongs), supplies such as flux, rivets, old files, new files, etc. When you go to the hardware store and you see a set of screwdrivers, for example, on sale at a ridiculously low price, buy it and bring it to the conference for IITH. I have already had folks drop donations off with me so it's not too early to think about what you want to donate. Each year I manage to bring a few things and I used to wonder what would be appropriate. It finally hit me that if I would be interested in a certain item, chances are somebody else would be interested in it, too. So now when I'm standing at the bargain bin at Harbor Freight, I buy things that I'd like to have. Simple stuff like epoxy, sandpaper, soapstone, steel tapes, etc are always welcome.

So, we've talked about donors. The other part of the deal that makes it work is buyers. Even if you show up at the conference without anything to donate to IITH, you can buy tickets. They will be on sale by several sellers. You can't win if you don't play.

Not everybody who comes to the conference brings donations. Not everybody who comes buys tickets. Not everybody who buys tickets wins something but every little bit helps raise a buck for the association. It's not cheap to put on a conference and we've managed to keep registration fees low for many years. Think about this: if 100 conference attendees buy \$10 worth of IITH tickets, that's \$1000 that can go a long way toward paying for demonstrators, travel, materials, etc.

(This article is being repeated by request from the August 2018 Newsletter - Editor)

Little Giant Power Hammer Rebuilding Class October 15-17 Nebraska City, NE

Attached (*see next page*) is information for the last Little Giant power hammer rebuilding class that will be taught by Sid Suedmeier, former owner of the Little Giant company. The business has been bought by longtime friends David Sloan and Doug Klaus, and they intend to carry on the rebuilding class.

Thank you so much for your support through the years in promoting the rebuilding class. We hope it will help keep the machines and blacksmithing alive for generations to come.

- Doug Klaus



**LEARN HOW TO MAKE YOUR
LITTLE GIANT POWER HAMMER
WORK HARDER THAN EVER!**

In 1991, Sid Suedmeier, having recently acquired the dusty remains of the Little Giant business, hosted his first Little Giant Hammer rebuilding class.

The class and Sid were taught by our good friend Fred Caylor of Zionsville, Indiana, at that time one of few authorities on these antique machines. As Fred grew older, Sid took over teaching the class, and has taught at best count 27 classes.

Sid sold Little Giant, the parts and repair business, to his long time machinist in 2013, and just this year the business made a move to our good and capable friends, David Sloan and Doug Klaus.

This 2 1/2 day class is a hands-on format. You will help transform a 25 LB Little Giant hammer from sloppy to sharp. This is the last class that Sid Suedmeier, intends to teach. He will be handing the reins over to David Sloan, who has attended at least 15 classes and has assisted Sid through the years.

An old style 25 LB Little Giant will be rebuilt during the class, and a new style machine will be on hand to demonstrate proper assembly and adjustment of both styles.

**IF YOU HAVE A LITTLE GIANT, THIS
CLASS IS FOR YOU!**

No experience is required to attend this class. Past students have ranged from age 15 to 90, and from all walks of life. Anyone who wants to learn will benefit from this class. We approach the rebuilding process using tools that can be found in the average home workshop. If you are in the market to buy a power hammer, this class will make you an educated shopper. If you already own a Little Giant, or any other brand of power hammer, this class will teach you how to get the best performance possible.

The class costs \$95, refundable up to 7 days prior to the class; advance registration is required. We will limit the number of students. The class starts at 9 AM sharp on Friday, and usually ends by Saturday evening. We will be available on Sunday until noon in case we encounter any exceptional problems in rebuilding, and to answer remaining questions.

When we receive your registration we will send you a city map, along with travel and hotel information.

**School Dates
October 15-17
2021 REGISTRATION**

Name: _____
Business name: _____
Address: _____
Telephone: _____
Email address: _____

**Since we no longer operate a business,
payment needs to be by check or money
order. Checks should be made out to
Sid Suedmeier.**

POWER HAMMER INFO

Brand: _____
Size: _____
Serial Number: _____

*Please call or email if you have any questions, or
prefer to register by phone. You can reach us at
402.873.6605 or Sidsshop@windstream.net.*

*Sid's shop is located at 420 4th Corso, Nebraska
City, NE 68410.*

Around the State...

NW Region August Meeting: No meeting was held.

NE Region September Meeting: The September SCABA Northeast meeting was held by Tracy Cowart at Dan & Tracy Cowart's forge, the 'Rusty Dragon Forge' in Wann, OK. The day was great and the meeting went very well. Tracy cooked up a great brisket for lunch and we had a lot of extras. We had a good turn out and made a lot of outdoor cooking items at the meeting. For several members it was the first items they had ever made.

We all thought of Charlie Groom and missed him. Aubrey Washington came by after the funeral and talked to us about it.

The weather was great even though it did rain for a few minutes but did no harm. It was a lot cooler than I thought it would be. - Danny Cowart









Around the State (Continued)...

SE Region September Meeting: No meeting was held.

SW Region September Meeting: No meeting info available at this time.

Beginner Blacksmith Workshop Overflow (August 21st):

The Beginner Blacksmith Class in Elk City on July 31st was more than a full class so Mandell scheduled a follow up class for the overflow.

The overflow class was also held at the Elk City blacksmith shop and five of the registered students made it to the class.

I want to thank everyone who helped with the class and the meal. I also want to thank the Elk City Museum for providing a place to have the class. - Mandell Greteman













Saltfork Craftsmen Artist-Blacksmith Association

Around the State (Continued)...

Pioneer Day - Cheyenne, OK:

We had a lot of young participants at our demo at Pioneer Day in Cheyenne, OK on September 11th. I think the kids had a great time learning how to beat hot steel thanks to Mandell Greteman, Don Garner, Monte Smith, Terry Kauk, and Rory Kirk. I think blacksmithing has a positive influence on our younger generation. - Rory Kirk

Rory Kirk and knifemaker, Joe Hay, collaborated on a donation project for a fundraiser held by the Historic Roger Mills County Preservation and Development Foundation. Rory made the damascus billet for the knife and the hinges and latch for the display box. The donation reportedly brought a very good price for the foundation. - Editor

- Mark Your Calendars -
September 11th, 2021 - 10a till 2p - Events and Activities
Cheyenne City Museums in the Park

PIONEER DAY

SILENT AUCTION FUNDRAISER

This year the Foundation will host a Silent Auction at the Sleif House



This year the Foundation will host a Silent Auction at the Sleif House Museum. Included in the auction for bidding is this handmade knife and wood box. The knife is made with Damascus Steel and hand forged by local blacksmith Rory Kirk of Cheyenne. Local wood craftsman, Joe Hay of Cheyenne, constructed the wood box of oak and walnut. Rory Kirk crafted the handmade forged hinges and latch as well. This auction item will be on display for viewing at the Pioneer Museum until the silent auction. The Foundation would like to thank Rory Kirk and Joe Hay for their incredible talents and donating this knife and box to the auction.

Also, get your tickets for the Raffle drawing for two Treager Grills. See details in the Cheyenne Star and on Facebook @ Historic Roger Mills County Preservation and Development Foundation. Tickets will be available for purchase on Pioneer Day, Sat. Sept. 11th from 10a till 1:30p before the drawing.

All guests are encouraged to consider their health as well as the health of their neighbors and follow standard COVID protective recommendations.

Museum Hours: Mar. 1st through Dec. 31st - Tues. thru Sat. 10a to 4p - PH: 505.497.3882 - Donations Welcome









2021 Oklahoma State Fair

It was **Back 2 Fun in 21** at the Oklahoma State Fair. We wrapped up demonstrating on Sunday, September 26. The weather was perfect without any rain (only a few sprinkles) and the temperatures were great for forging in the shade.

We want to personally thank each and every person that played a part in pulling off this year's demonstration for the public. While we got off to a slow scheduling start and had to do a little recruiting, we were able to fill all the days with some people adding extra days along the way.

As usual, Byron is so willing to get the trailer over to the OKC fairgrounds. With recent elbow surgery he was still able to get the trailer delivered, in place and stocked with enough coal for the entire week. THANK YOU, Byron!!

It takes many people helping out to make this event work, and Saltfork benefits with a payment for doing this event for the fairgoers. Several of our "regulars" took the year off because of other commitments. We look forward to them returning next year.

Anthony and Cheryl Griggs made several trips from Sparks, Oklahoma (55 miles one way) to cover 4 days. I know Cheryl spoiled the guys with fresh baked treats every day she came in. Roy Bell from Clinton, Oklahoma (75 miles) worked a total 7 days and was gracious to split his time up, making 2 trips to the city and allowing Douglass Hyde from Canyon, Texas (274 miles) to utilize the hotel. Mark Carter from Stillwater, Lloyd Turner and his wife LaNeal from Chickasha, Gerald Franklin from Norman, Jason O'Dell from Harrah, Leonard "Dale" Dixon from Mustang, Mike Porter from Mustang, Eric Jergensen from OKC, Jim Fullwood from OKC, Doni Ulfheddin from OKC and Richard Blasius from Yukon all helped out this year.

We were selling items faster than we could hammer them out. Richard took on the task of making items for the mutton busting winners (2 daily) since the soap lady (who provided prizes) was unable to be there this year due to health issues. Several others joined in and provided an assortment of prizes for the little kids to choose from. They really enjoyed that.

Everyone did an overall great job!! Those working with me on the last day helped with disassembling the area and reorganizing the trailer. Thank you, Gerald, Jason and Doni, you were a tremendous help.

We look forward to organizing this event again next year. Please mark your calendars for next year September 15-25, 2022.

Richard and Michele Blasius



Richard Blasius



Anthony Griggs



Douglas Hyde



Donnie Ulfheddin



Eric Jergensen



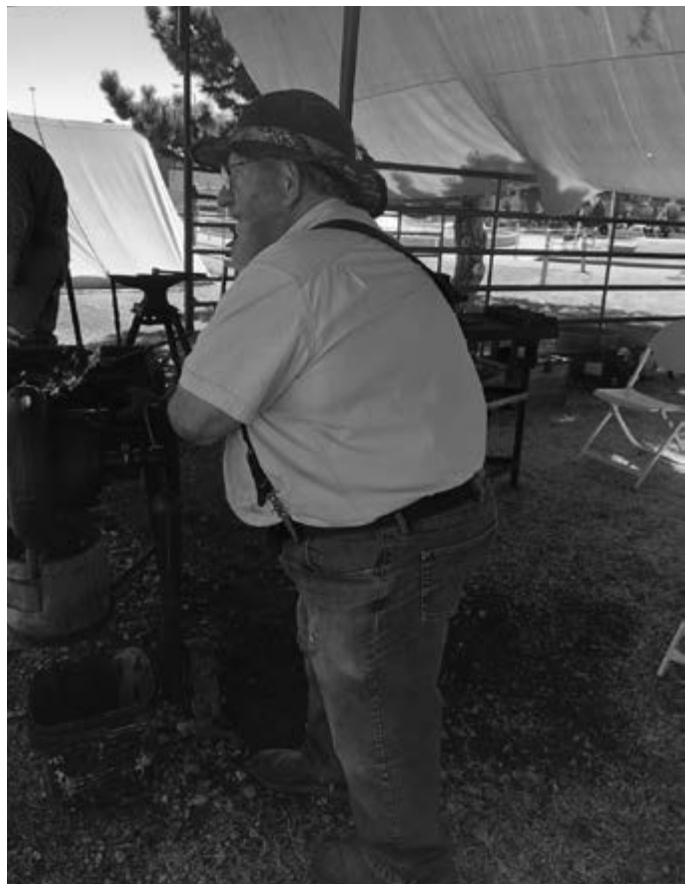
Gerald Franklin



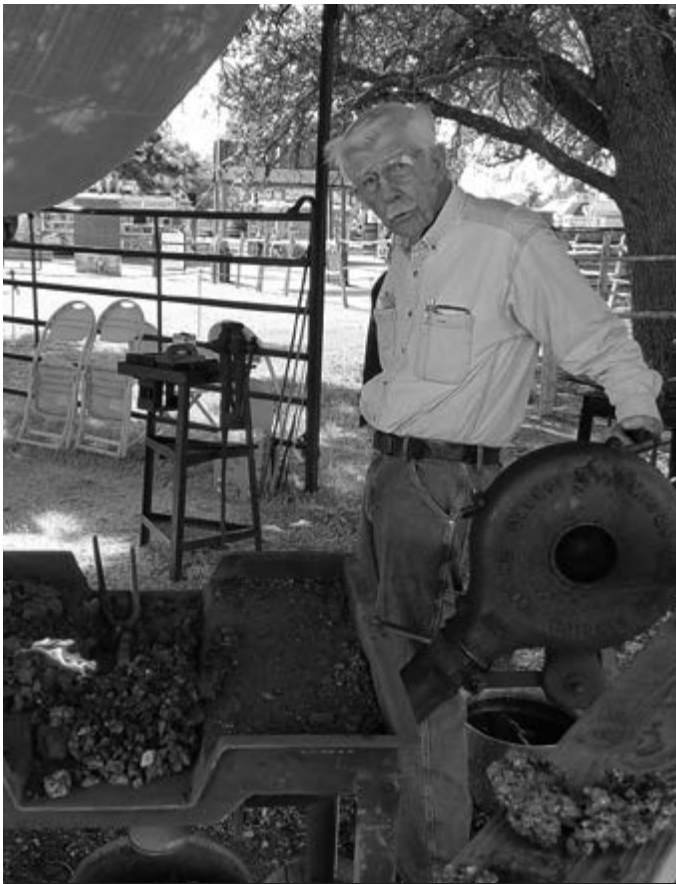
Jason Odell



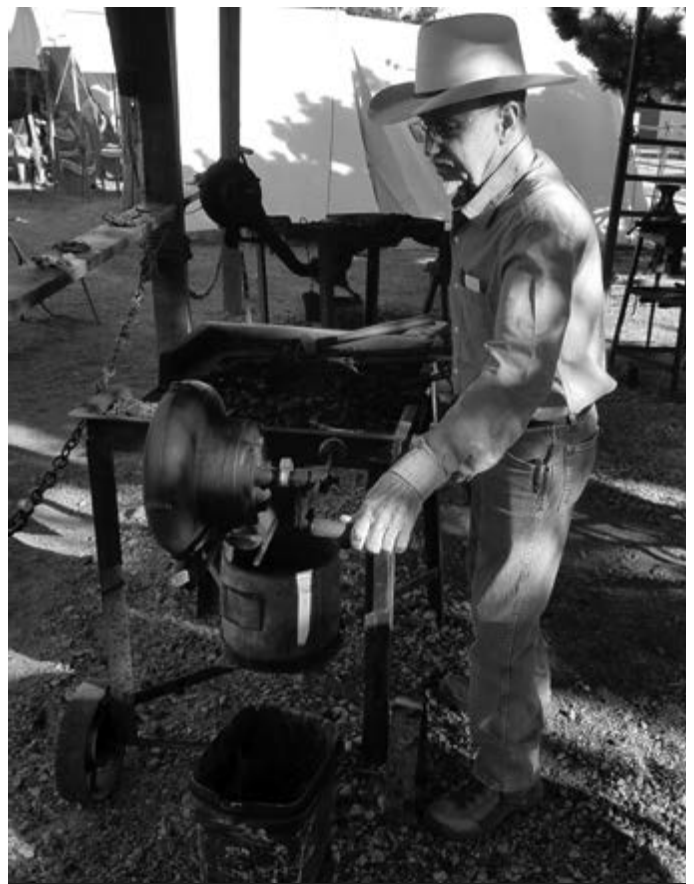
Mark Carter



Jim Fullwood



Dale Dixon



Mike Porter



Richard and Lloyd with Mutton Busting Winner



Roy Bell and Lloyd Turner

Member Gallery

Horseless Carriage by Gerald Brostek

I created this carriage with the inspiration of Ransom Ely Olds' carriage that he built in 1901 called CDO (curved dash olds). Dick Carlson built a horseless carriage and brought it to the BAM conference in Sedalia, Mo. this year. I was impressed with his and decided I would have to build one. Dick was kind enough to give me advice and a frame plan. Since I did not want to copy Dick's carriage I greatly modified the plan to suite what I wanted my carriage to be. It was both fun and challenging to build. It is powered by an 11.5 HP Briggs-stratton vertical shaft engine, and belt drive to a Tuf-Torque hydrostatic drive. I went with 26 in. spoke wheels and tiller steering. The frame is mostly 11ga. X 1" square tube. The body is 3/4 " plywood. There is very little hot forging on this project - just the steps, hand holds, and steering linkage.

- Gerald Brostek, now, Master Carriage Builder. lol.





DRILLING HOLES:

A Few Pointers From A Machinist



By **Mike Clifton**

INTRODUCTION

When working with metal, frequently the need arises to drill a hole. I'm sure you have multiple personal examples of when you have had a small drill bit break, or a larger drill bit becoming dull because the cutting edge overheated, or some other drilling struggle. Here, I will talk about how to adjust your RPM and drilling pressure, along with what cutting fluids might help you, based on what type of drilling you are doing. I will also mention some different cutting speeds for different metals. A very common fabricating material is low carbon steel, so many of my examples will be for low carbon steel.

"Cutting speed" or "Surface Feet" (240 divided by drill bit diameter equals RPM)

When drilling a small hole, the initial tendency is to have your RPM too slow. This often results in the drill bit breaking, because the pressure being applied (the "feed rate") at low speed results in too much "chip load," meaning it's trying to cut too much in one revolution. If you were to calculate your RPM using formulas for "cutting speed" or "surface footage" (they are the same thing) you might be surprised at what the speed should be.

For example, if I were to run a 1/2" drill bit at 480 RPM, that would generate the same amount of "cutting speed" as if I ran a 1/8" drill bit at 1920 RPM. If you are running a small bit at a higher speed the same amount of downward pressure will create a much smaller chip and put less torque on the drill bit. This will help you with 2 things: One, you will have less tendency to break the drill; and two, you will get through the hole faster.

From my observations, people naturally tend to get the correct "cutting speed" when using a drill around 1/2 inch. What I have seen commonly is the tendency to run smaller drills at too low an RPM, which puts too much torque on the drill, and it tends to break. Conversely, the tendency is to run larger drills at too high an RPM, which generates too much heat, and the cutting edge will tend to burn up



in a very short time – sometimes less than one second.

For example, if I were to run a 3/4 inch drill bit at 500 RPM that would be too fast.

The RPM that would equal the "cutting speed" in the 1/2 inch example would be 320 RPM. A lot of drill presses and larger hand drills have trouble going that slow. To take this one step further, if I ran a 2-inch hole saw, the RPM would be 120 to achieve the same "cutting speed."

HOW TO DETERMINE YOUR "CUTTING SPEED"

Here is the simplest formula to come up with an RPM that will work with a wide variety of low-carbon steels:

$$\frac{240}{\text{drill bit diameter}} = \text{RPM}$$

Here is the math behind the formula. For all low and medium carbon steels, a "cutting speed" of 60 will work, and for high carbon and stainless steels, 30 will work. For aluminum, a "cutting speed" of 400 will work. There is a range of "cutting speeds" and many variables for these metals, but this is me keeping it as straightforward as possible. You can get these numbers from the internet, cutting tool manufacturers, the Machinery's Handbook, an experienced person, or many other sources. There is a more complex formula called out in technical reference manuals;

Drilling Holes

however, I have reduced it here. This more complex formula matters if you are machining at over 10,000 RPM, but this is simpler and works just fine for our purposes here. This formula will work for a lathe, a mill, a band saw – anywhere you have a cutter moving across metal.

You would take the 60 times 4, divided by the diameter of your drill bit.

$$\frac{60 \times 4}{\text{drill bit diameter}} = \text{RPM}$$

For example, if I wanted to run a ½” drill bit at a cutting speed of 60, I would take 60 times 4 and divide by .5, which would equal 480 RPM. After teaching machining for over 20 years, I found many sources that said for mild or low-carbon steel using a high-speed steel drill bit (versus carbide), you can run at a cutting speed between 40 and 120. I found that 120 works well when using a CNC machine and running some kind of a cutting fluid to keep the heat down. I found that with beginning students, running a cutting speed between 60 to 100 surface feet worked out well for them. Many times, they had cutters that were a little dull or setups that were a little weak, and very rarely were they running cutting fluid (sometimes used to cool, sometimes used to lubricate). I would use a cutting speed of 40 surface feet if I were using a very low-quality drill bit.

ESTIMATING YOUR RPM AND USING COOLANT

So, what do you do when using a hand drill and you don't know what RPM you are running? Start with guessing. We all can tell if the drill is running at its full speed or barely turning. For small drills, pay attention to your chip. If you start seeing your chip get very thick, you need more RPM and less pressure. For larger drills, if your chips are blue you are starting to run too fast.

Let's take the problem of blue chips and let's say that you're running as slow as your drill will go. What you then need is something to remove the heat. The 3 most basic choices are air, oil, and water. Compressed air can help remove the chips and cool the drill bit. Oil does have a cooling effect but tends to smoke and does not cool nearly as well as water. Oil is much better at lubricating than cooling. If you have the choice, “coolant” works the best. Coolant is water-soluble oil or synthetic mixed with water. There are many on the market. Most coolants are over 90% water and for that reason if you don't have coolant, use water. If you spray water or coolant on the drill bit and it steams, it is helping cool the

drill. If it doesn't steam you probably don't need it. (The only reason not to use it is that it is messy).

I was drilling a hole in an implement for my tractor, using a hand drill, and I needed a 7/8” diameter hole. The drill I was using ran at 600 RPM which was too fast; it would have burned up the cutting tips on my drill. I needed to get rid of the heat, but I didn't have flood coolant (coolant from a hose versus a spray bottle or mister); however, I did have a hose and water. My friend held the hose on the drill bit with a slow water flow, and we made it through a piece of 3/8” steel without having to sharpen the drill bit.

DRILLING A LARGE HOLE

When drilling larger holes, a common practice is to drill a small hole in your material, and then work your way up. The reasoning is that it takes less force or pressure to move the drill through the material. The problem is that the drill bit tends to grab, which can break the bit, or it can get stuck. For example, if you are drilling a ½” hole, the tendency is to drill a 3/16”, then a 3/8”, and then your ½” hole. I am recommending that you try using a pilot hole just a bit larger than the chisel point on your final drill bit, and drill the hole in two steps. (Drill a 3/16” hole, and then your ½”). This reduces the pressure needed and still avoids most of the grabbing and chattering. Of course, as in all of these examples, there are so many variables that there is no one guaranteed solution. Variables can include hot-rolled versus cold-rolled steel, high-helix versus low-helix drill bits, drills with extra wide webs for good strength, using a hand drill versus a drill press versus a milling machine, cutting dry versus using fluids; the list is considerable.

Another tip to note: A drill bit with a split point will take less pressure than a drill bit with a chisel point.



SPLIT POINT DRILL BIT

Drilling Holes

If you look at the center of the drill you can see the chisel point is split, creating two cutting edges on the point. This will take less pressure because the chisel point only pushes metal away whereas the split point is actually cutting.



CHISEL POINT DRILL BIT

TYPES OF DRILL BITS

What kind of drill bit works best for drilling steel? This is a very complicated question and there are entire companies that are devoted to creating all different kinds of drill bits. Gehrting is one that will show you the astonishing variety of drill bits. Their printed catalog of drill bits looks like an old-fashioned city phone book. I am not going to attempt to go into any depth on drill bits. I am going to look at the three drill bits for metal I see most commonly in a hardware store.

One will be black and most likely the least expensive there. It may have a lower quality finish grind, and many times does not have a

split point. Works well for drilling wood. Another will have a gold coating and it's probably a very good choice. This gold coating is harder and more slippery and works better than the substrate that the drill is made of. That doesn't mean you can't sharpen one of these drills - you just lose the benefit of the coating.

The third common option you may have at the hardware store will be a cobalt drill bit and this is usually the best drill bit you can find there for drilling steels. These are usually better-quality drills in regard to grind and finish, but they are usually the most expensive. Cobalt increases what is called "red hardness." Red Hardness means that the cutting edge stays strong even when it gets red-hot. The cobalt gives it strength and keeps it from breaking down. Notice that your drill bit may not be red-hot but the very fine cutting edge that is doing the bulk of the work can become red-hot. If you buy your drill bits from a tool supply house or some other source that has more choices you will see that some of the most common choices are cobalt at 3%, 5% and 7%. As the percentage of cobalt goes up, the drill will do a better job of holding up to heat.

STAINLESS STEEL

When drilling stainless steel, I have found at least 5% cobalt holds up well. I will very briefly cover helix and web thickness. When a drill has a "high helix," or a lot of twist, the cutting angle changes. This can work well in stainless steel and aluminum. When your drill has a thick "web" (the center shaft), this makes your drill much stronger, but you will need more force. You need that web thickness if you are being

aggressive and drilling through a tough material like stainless. I'm not going to cover carbide drills because most of us can only get the carbide drills available for drilling concrete.

Stainless is tougher than low carbon steel but it is not necessarily "harder" so it's more like drilling rubber than glass. Toughness is the metal's ability to resist impact, and hardness is the metal's ability to resist penetration. For stainless, you need a sharp drill bit (Will the cutting edge of the drill scratch your fingernail? If not, it's not sharp enough for stainless). You'll need to slow your cutting speed down to somewhere close to 35 to calculate your RPM. You do not want your drill bit to rub. This can cause "work hardening." To keep your drill bit from rubbing you need a little higher feed rate or more pressure. If you're not making a chip you're rubbing. What is "work hardening"? Hardening a metal as a result of "cold-working." "Work-hardening" is when your drill rubs and creates a hard spot a few thousandths thick where you are drilling. (Hammering can also cause "work hardening"). There are three grain structures in steel, including stainless: Austenitic, Ferritic, and Martensitic. "Work hardening" for the most part only happens in Austenitic stainless. Knife steel is usually Martensitic. Austenitic is frequently used in marine hardware. Ferritic may be the exhaust system on a motorcycle.

I would use oil, or coolant with a higher percent of cutting fluid, not water. Stainless needs the lubrication. The other thing that can help is to peck drill. This can help any time you are drilling a

Drilling Holes

deep hole or need to keep the cutting fluid at the tip of the cutter. Peck drilling is when you drill a little and then pull your drill out of the hole to remove the chips and to get cutting fluid down in the hole.

BRIEF NOTE ON ALUMINUM AND BRASS:

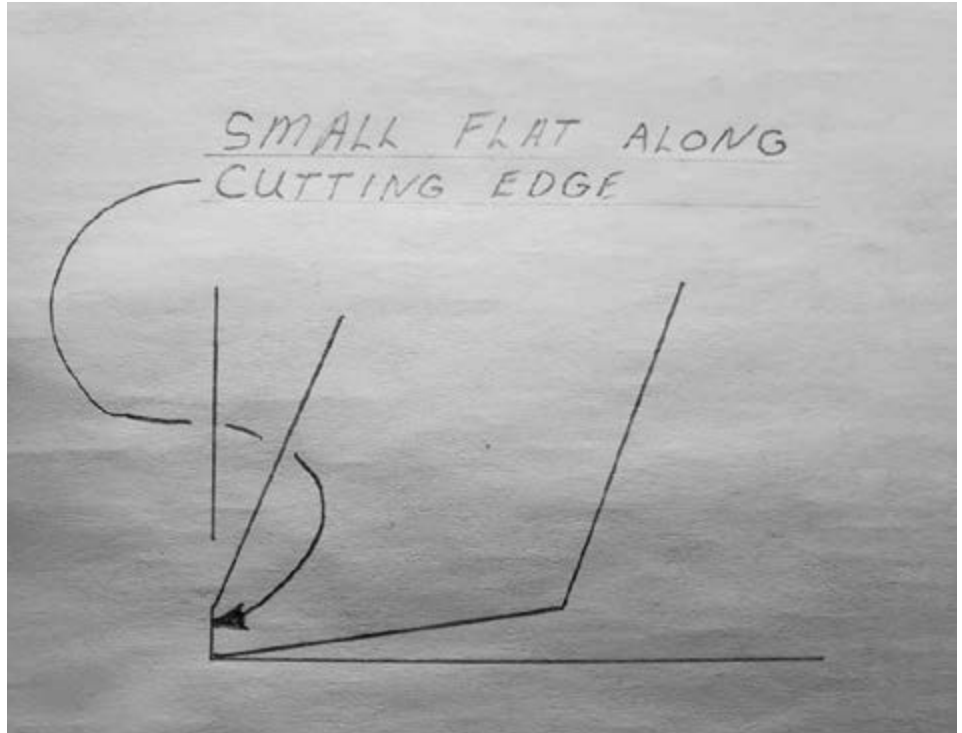
When drilling in aluminum, you can run at a very high cutting speed. 400 to 600 surface feet is common. That means a ½" drill bit could run at 4,000 to 5,000 RPM. One problem you will start to see is that the material will start to melt and stick to your drill bit. A small amount of cutting oil can greatly improve your success when drilling aluminum. Even though I may not be running at the high speeds mentioned above, I quite commonly will put a little cutting fluid on my drill bit. When I'm at home I've been known to use WD-40.

When drilling brass, you typically don't need any cutting fluid. But if you are drilling a deep hole in brass, you may experience the problem that your drill bit gets stuck in the hole. The brass is slippery enough that the drill starts working like a screw and cannot eject the chips as fast as it's being pulled into the material. A common solution for this is "dubbing" the drill bit.

"Dubbing" the drill bit is using a stone or lightly touch it to a grinding wheel to remove the helix, or "rake angle," from the cutting edge. The flat needs to be greater than your chip thickness, typically between .005 and .030 thousandths.

The diagram above shows the small flat, or removal of the helix, parallel to the center of the drill.

There are many techniques and tips in here that can be done in different ways, using different methods and numbers. My goal was to introduce you to a lot of these concepts and try to keep things simple.



DUBBED DRILL BIT

Editor's Note: We are pleased to welcome Mike Clifton to Hot Iron News as a regular contributor. Mike has worked in machining for his entire career of nearly 50 years. He has worked in the Aerospace, marine and nuclear industries. For the last 22 years, he taught both manual and CNC machining. He lives with his family on their small horse farm in Snohomish, Washington. Mike has always loved building things. He has shops for woodworking, blacksmithing, and welding; and enjoys using them and his tractors to keep his farm running smoothly. Thank you Mike for so generously agreeing to share your expertise with the readers of Hot Iron News.



ABANA'S Education Committee Announces the National Curriculum

From ABANA: We have some exciting news from the Education Committee; ABANA has fully adopted the National Curriculum (NC), based on the curriculum of the CBA (California Blacksmith Association).

As our core mission is to perpetuate the noble art of blacksmithing, we recognize it's incumbent as a national blacksmithing organization, to share a successful and practical working curriculum with members, affiliates, and the blacksmithing world at large.

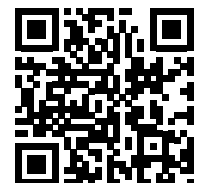
What is the National Curriculum? The NC is a departure point for those that seek a structured program of study that can be used at schools, conferences, meetings, and individual shops through one on one, small groups and self-guided study.

We present the curriculum as one way to learn blacksmithing, but certainly not the only way. From this set of goals, lessons, and benchmarks, smiths at any skill level can pick this up and continue their education. The curriculum provides the framework for the student to progress through increasingly challenging projects that focus on the skills expected of a journeyman smith, culminating with the Level III Grille. - ABANA Education Committee.



If you are interested in finding out more about the curriculum, information on all three levels is available on ABANA's website:

<https://abana.org/abana-curriculum/>



Mark Aspery has shared a series of articles from the CBA related to the Level III Grille Project and its associated tooling. I will include this series in upcoming newsletters for those who are interested. This is essentially the same information that ABANA is adopting and additional information and resources can be found on their website. - Editor

THE CALIFORNIA BLACKSMITH ASSOCIATION LEVEL III GRILLE (PART 4)



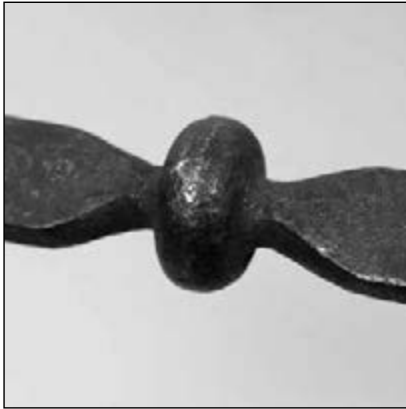
The CBA Level III Grille

Part-4

Mark Aspery

Continuing on from the article in the last issue of the CBA online magazine, this article looks at the welded collars on the center style of the grille.

There are two welded collars on the bar. The collars are elliptical in cross section, welded to a necked in portion of a rectangular bar.



An example of the welded collar on rectangular stock featured on the Level II grille

The rectangular bar is going to dictate the method used to create the weld.

Firstly, let's look at a welded collar on a round bar - a good example of this may be a collar used to form the hip of a rose stem.

We know that when we bend a flat bar the easy way, that the sides are deflected away from the bend.



A welded collar on round stock forming the hip of a rose at the base of the flower



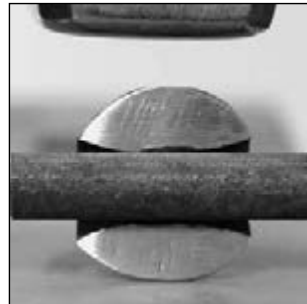
A flat bar bent the easy way has deflected the edges away from the bend



The collar material is also deflecting its edges away from the bend as it is wrapped around the stem of the rose. Looking at the photographs above, you can see the deflected edge material of a bend, and if you look at the collar being wrapped around the stem of the rose, you can see the same deflection.

The photographs below show a more detailed view of the collar.

The issue doesn't cause us too many problems, as we just make the weld in two steps, weld the middle of the collar and then weld the edges.



Welding a collar onto a length of round bar is a two step process, first weld the middle of the collar and then weld the edges of the collar at the edge of the anvil

Looking at the rose, hold the rose stem horizontal as you complete the first step in welding the collar, then hold the stem at a 45-degree angle to the nearside edge as you complete the second step of the weld.

Having a round bar as the material to which you are welding the collar gives you clearance for the toe of your hammer as you complete the second step of the collar weld.



Welding a collar onto a rose stem to form the rose hip

If we look again to the grille, we are welding a collar onto rectangular flat stock, and the clearance for the toe of the hammer is now removed.

We have to find another way to weld the edges of the collar to the bar.

For me, I see using a set of top and bottom dies to capture the bar and collar to help make the weld complete once the collar is wrapped around the necked-in bar.



A collar wrapped around the necked-in rectangular bar of the center style of the grille

I have two options, an open die or a closed die method.

The open die method allows the collar material to spread and has a small contact patch on the collar which can sometimes form flat spots on the collar - rather like looking at the perimeter of a cross section of an orange cut horizontally.

That's not the look that I want, so I'm going with a closed dies method of capturing the collar and bar.

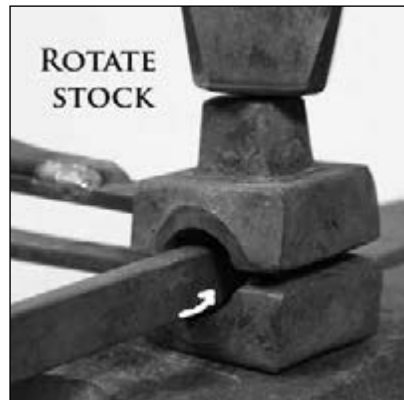


A clam shell that makes my closed die tooling to complete the welded collar

The tooling pictured above is of two bottom swages, one of which has had a portion of the peg cut of and flipped over to make a top tool.

These two parts of my dies are electrically welded to a staple make from 1-inch by 1/4-inch thick flat bar to give me a hands-free operating tool.

I need one hand on my hammer, and another on the hot bar, rotating the bar between the dies as I hammer from above.



The stock is rotated within the clam shell to complete the weld; this dictates some features of the tooling

But what does the inside of the tooling look like, and how do we achieve it?

The first thing to note from the last photograph, is that the stock is rotated under the dies.

Because the rectangular bar is rotated within the clam shell, we have to treat the flat stock as if it were round bar, and our tooling should reflect that understanding.



A blank to help make the clam shell tooling shown above the desired outcome

To give myself some clearance, I choose a round bar that is slightly bigger than the dimensions of the flat bar. I went with 1-inch diameter in the picture above, but I suspect that $\frac{7}{8}$ -inch diameter will work just fine.

Using a guillotine tool with off-set fullering dies (blunt butcher dies), I fullered in on either side of what would become the collar, isolating the mass.

A little wipe over with a half-round file and or a belt sander finishes the job.

What I need to say now is that the collar is larger than 1-inch in diameter. An off-set fuller has more surface area on one side of the working edge than the other.

As the edge enters the hot bar, the tool will move towards the path of least resistance, and that's the side with less surface area.

That movement is going to push material into the isolated collar.

Moving on to the tooling, I know that I have a lot of work to do to 'let-in' the blank that I just made.

As I want some room between the bottom of the welded bar and the face of the anvil, I'm going to make my bottom tooling blanks a little taller than I would normally, which means that they will form a slightly smaller square of material when viewed from above.

I am for $1\frac{3}{8}$ -inch to $1\frac{1}{2}$ -inch tall by whatever I get square.

Now I'm going to look at the blank that we made. In essence, it is two tapered cones leading into an elliptical shaped object.

The cones do not come to a point, but are truncated, so I consider this a third piece of the blank, and that's a round bar the same size as the truncated cone that runs through the whole tool.

I start to let-in the blank starting with this imagined round bar.



I believe that the collar will wrap around a forged $\frac{7}{16}$ -inch round bar.

I necked in some center-style bar material to conducted test pieces on the result. The test pieces have shown me that I yield a $\frac{7}{16}$ -inch round bar at the necking in point.

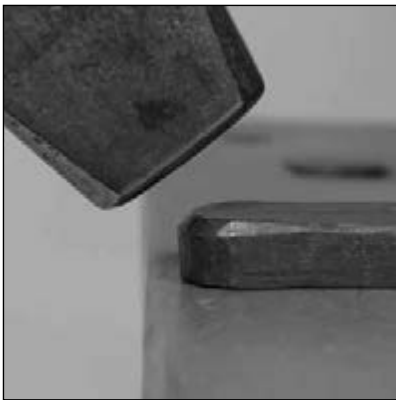
To allow for a little cleanup of the top and bottom swages, I'm going to go a little under that measurement for my first step in making the top and bottom tools.

After forging and filing, I have a hand-held fuller that is a little under $\frac{3}{8}$ -inch thick.

Why hand-held? Because I intend to use it later on in the process to let in the cones of the blank.

Next I let in the area for the collar. I need that now - even though it runs the risk of being damaged, as I need to know where the cones stop.

I know from the supplied drawing that the collar is 1-inch in diameter and a $\frac{1}{2}$ -inch thick.



Shaping the end of a flat bar to look like the intended result of the welded collar

Putting a half-round end on a piece of 1-inch wide by $\frac{1}{2}$ -inch thick flat bar, I drive that into the middle of my bottom swage.

Ultimately, the tool needs to be driven in to a depth of $\frac{1}{2}$ -inch deep from the top surface of the bottom swage - but don't go there yet, allow yourself a little room for cleanup.



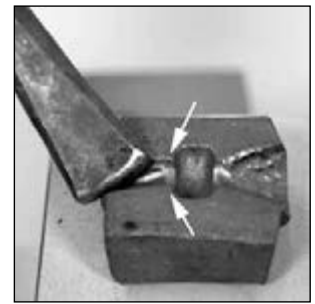
The result of driving in the half-round end of the flat bar to make the recess for the collar material

Reaching for the hand-held fuller, I now start to let in for the cone material.

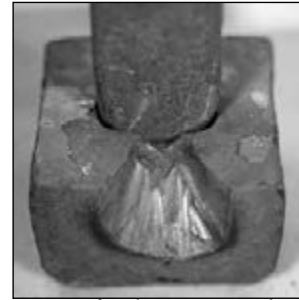
Take care when you do this, don't crush the material on the sides of the depression for the collar.

You cannot go too deep, as the object has to allow clearance of the flat bar during welding.

But, going too deep is extra work and it will squash your bottom tool height.



Using a hand-held fuller to let-in the recess for the cone material of the blank



Left: cleaning up the recess for the collar material and right: the result with the blank shown for comparison

Once you have moved the material away to allow for the cones, go back and clean up the collar depression with the 1-inch by $\frac{1}{2}$ -inch flat bar.

The last photograph in the series shows the blank above the work that you have done. Note that there is a flat spot on the collar material of the blank.

Remember that the collar material was swelled due to the creep of the off-set fullers earlier?

The blank needs to be covered with a flatter when driven home into the bottom swage.

I have found that using a hammer directly cracks that tight area (stress riser) around the sides of the collar material at the top of the cones.

Bring the collar material back down to level with the remainder of the bar at the point where you'll place the flatter.



Using a flatter to deliver an even blow will help prevent damage to the blank

Heat up the bottom swage and drive the blank into place using a hammer and flatter.

This is a stout move and one that makes you appreciate the effort going in to moving a lot of the excess material out of the way initially.

Keep the bottom swage hot, this may be a two heat move.



The result on one half of the clam-shell tooling

Allow the bottom swage to cool and then run a round file around the cone to collar transition point, bringing the area back to $\frac{7}{16}$ -inch diameter.

After you have made two of these, place them together with the blank between the two, to assist in alignment, and then weld on the staple.

I typically use the tool a couple of times before i worry about case hardening it.



The blank wired in place to keep both sides in alignment as the staple is welded in place



My hammer is keeping the dies apart as I place the hot material between the clam shell tooling

Placing your hammer between the sides of the staple keeps the dies apart when you are positioning the collar for welding.

This article was written to support the CBA Level III Grille curriculum and the corresponding CBA Zoom tutorials, both CBA initiatives.

This article is reprinted with permission from the California Blacksmith Association - Submitted by Mark Aspery.

ABANA Affiliate Newsletter - September 2021

Artist-Blacksmith's Association of North America
47 Walnut Street, Suite 200
Johnstown, PA 15901-1521

Hello Affiliates,

I hope this month's newsletter finds you all busy and safe in the shop, busy creating and forging one of a kind pieces and sharing our tricks and tips. With the changing colors of the leaves come the changing of temperatures and the change of shop dress attire. Please remember to wear appropriate clothing for the task ie: long pants (denim or cotton or a leather smithy apron) cotton shirt (save polyester for the gym) closed toe shoes and safety glasses are a must.

We are looking for Affiliate photo submissions of your individual or group projects to share in our monthly newsletter. Send your photos to ironcloverforge@gmail.com with your name (s) Affiliate name and Affiliate location and what you're creating.

Thank you to all our Affiliate groups for your hard work, dedication to the craft and perseverance during this trying COVID time.

Respectfully Yours,

Chris Rowan
ABANA Board of Director
ABANA Affiliate Chairman

Iron to Art Festival Tickets are on Sale:

The dates are set, October 14 through October 16, 2021. ABANA will host the Iron to Art Festival at our new headquarters in Johnstown, Pennsylvania. Tickets are on sale now. event.abana.org

- Member registration: After 8/30 (late registration) \$165.00
- Member Spouse registration: After 8/30 (late registration) \$75.00
- Non-Member registration: After 8/30 (late registration) \$245.00
- Non-Member Spouse registration: After 8/30 (late registration) \$90.00

ABANA would like to interest you in being a Craft Vendor at Iron to Art Festival: This is our inaugural event in Johnstown, PA and ABANA wants you!!!!!! We are expecting 500 + visitors to the conference with 5000 visitors to Johnstown itself over this new 3 DAY EVENT and ABANA wants YOU to get in on the action. Rent a 12x12 vendor booth for the low cost of \$250 (for all 3 days), comes with electricity and if you're performing live demonstrations for your craft you will receive an ADDITIONAL ½ space for free to showcase your skills. There will be visitors and exhibitors from far and wide, what a perfect venue to showcase your crafts and passions. See ABANA.org, Iron to Art, then click on the vendor icon and we will SEE YOU THERE!!

The Artist-Blacksmith's Association of North America is holding a special 'Affiliate's Day' on the last day of the Iron to Art Festival in Johnstown, PA on Saturday, October 16th. This day is open to the general public and ABANA expects over 1,000 attendees.

ABANA Affiliate Newsletter (Continued...)

ABANA will provide to affiliates:

A table for each affiliate organization to put information out and sell small items

If a group would like to hold a membership meeting during that day, ABANA will arrange a meeting room

We ask affiliates to 'fly their banner' at the festival! Bring a banner and ABANA will hang the affiliate's banner at the festival

This is a great way to raise awareness for your organization, increase membership, provide opportunities for your members to sell their work, and meet to enjoy this inaugural blacksmithing event!

For planning purposes, affiliate leaders should email ABANA's Executive Director, Janie Grela at exedir@abana.org to reserve a table and list members who plan to attend.

A Reminder about ABANA Membership Options and Pricing:

ABANA membership options and pricing changed as of April 15, 2021.

ABANA now offers two membership options: ABANA Digital or ABANA Print.

Each option offers the same membership benefits. The only difference is in the delivery method of ABANA's premier publications, the Anvil's Ring and the Hammer's Blow:

- **ABANA Digital** membership is available world-wide for \$55/year. (This is your only choice if you live outside of North America.) ABANA will send publications digitally to the member's e-mail address on file; no print copies will be mailed.

- **ABANA Print** membership is a \$65/year option for those whose mailing address is in North America (Canada-USA-Mexico); publications will be delivered to the Canada-USA-Mexico mailing address on file by the USPS.

The office has received a few checks in the mail using old forms which feature pricing and options no longer available. For example, the two-year membership option is no longer available. We regret any confusion this has caused to our valued members!

Moving forward, every effort will be made to contact those who mail in checks using old forms, and we'll inquire as to how you'd like proceed and/or to which membership option your payment should be directed.

Please be assured that existing memberships will be honored until they expire, at which point ABANA's current membership pricing options will be available.

Thank you for being a valued ABANA member, and please don't hesitate to reach out to us with any questions.

ABANA Affiliate Newsletter (Continued...)

Membership benefits include:

Publications: Four quarterly issues of the Anvil's Ring

Four quarterly issues of the Hammer's Blow Members-only access:

- to recent 5 years of digital publications
- to educational videos and materials
- to ABANA membership directory

Eligibility for education grants and scholarships

Option to join ABANA's 'Find a Blacksmith' module, searchable by the general public

Discounts: Conference registration, vendor booths, ABANA Store Voting rights, such as annual election of Board members to forge the future of blacksmithing

Participation in ABANA Board committees

Your Anvil's Ring and Hammer's Blow publications delivery is either by mail or by e-mail.

ABANA EDUCATION

This past year, ABANA has offered the National Curriculum to blacksmiths from all over the county and has certified both students and instructors in all three National Curriculum levels.

ABANA realizes that there are many skilled smiths among you, who have the work portfolio and experience to earn a National Curriculum certificate and - ABANA has a certificate waiting for you! If you are interested and believe you qualify, email the committee at: education.abana.org ABANA looks forward to hearing from you soon.

ABANA is creating a touchmark registry:

ABANA is creating a comprehensive registry of touchmarks. To submit your touchmark, please check the ABANA webpage and follow the instructions. <https://abana.org/touchmark-registry/>

Affiliate/ Member Funding

Affiliates and members have funding opportunities available to them through ABANA. Please see the website for all details, requirements, and deadlines. ABANA, the premier blacksmith and metal Art association, looks to perpetuate the craft and build your skills. Consider these opportunities

- INDIVIDUAL MATCHING AFFILIATE GRANT
- AFFILIATE EVENT &
- AFFILIATE MINI GRANT

<https://abana.org/education/scholarship-grants-and-scholarship-reports/> click here for more info to see which grant or funding is available to you or your group.

Sincerely,

Jerry Boyd
ABANA Affiliates Committee
Shop Helper
325-207-8253

ADDRESS

ABANA Home Office
PO Box 462, Johnstown PA 15907

GET IN TOUCH

Phone: (814) 254-4817
Email: exedir@abana.org

SCABA Shop and Swap

2021 Conference T-Shirt

T-Shirts must be pre-ordered. Please place your order by September 24th if you want your shirt at conference.



Back of T-Shirt



Pocket

There are two shirts to choose from this year.

The first is a 50/50 poly cotton blend. This shirt comes in tall sizes.

Port & Company® Tall Core Blend Tee. PC55T

Sizes range from Large Tall to 4X Large Tall.

COLOR INFORMATION										
Aquatic Blue PMS 2389C	Ash PMS COOL GRAY 3C	Athletic Heather PMS COOL GRAY 7C	Athletic Maroon PMS 209C	Carolina Blue PMS 7682C	Charcoal PMS COOL GRAY 11C	Dark Green PMS 560C	Dark Heather Grey PMS 7540C	Desert Sand PMS 2224C	Jet Black PMS NTR BLACK C	Kelly PMS 340C
Light Blue PMS 278C	Lime PMS 367C	Medium Grey PMS 2312C	Navy PMS 2180C	Orange PMS 177C	Purple PMS 7672C	Red PMS 200C	Royal PMS 2111C	Safety Green PMS 379C	Safety Orange PMS 021 C	Sapphire PMS 2185C
		<i>View the form in the online newsletter or Saltfork website to see the color selection</i>								
White	Yellow PMS 127C									

The second shirt is a tri-blend poly/cotton/rayon shirt. This is a much softer shirt.

BELLA+CANVAS
LOS ANGELES

3413C primeplus

Bella + Canvas Unisex Triblend T-Shirt

Small to 3X: \$15 Each

4X to 6X: \$20 Each

5X and 6X are special order and may be a different shirt. Contact Teresa for shirt details:

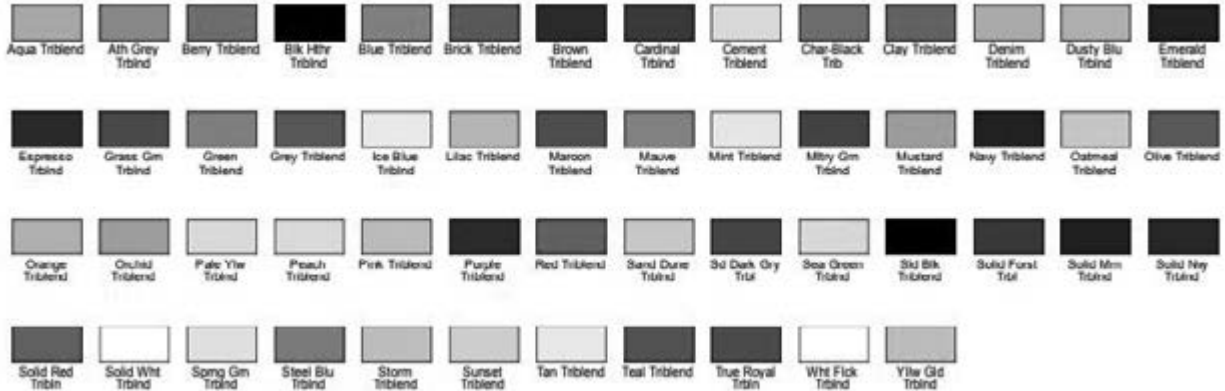
tgabrish@gmail.com

405-824-9681

Sizes range from an XS to a 4XL

View the form in the online newsletter or Saltfork website to see the color selection

53 Available Colors



Name: _____ **Phone:** _____

T-Shirt Style (Port or Bella)	Size	Color	Price	Number	Total

Make Checks Payable to Saltfork Cratsmen Artist Blacksmith Association

Mail to Teresa Gabrish, 23290 NE Wolf Road, Fletcher OK 73541

Shirts will be available to pick up at the Conference. For shirts ordered after the September 24th deadline or to have shirts mailed to you, contact Teresa to arrange shipping.

SCABA Shop and Swap

For Sale:

50 Lb Little Giant Power Hammer - Asking \$4,800

In good shape. Owned by me since 1961 or 1962. Has been on loan for several years with limited use and kept well oiled. Currently has a 3 phase motor installed. Located in Wagoner, OK. **Contact William Burling at 918-485-1508.**



For Sale:

Water Jet Services - Saltfork Discount

Taswallson Manufacturing is offering waterjet services at discounted rates for Saltfork members. I am currently operating nights and weekends.

Contact: **Ragnar at rtaswallson@yahoo.com or 918-855-8250.**

SCABA Shop and Swap



Your one-stop-shop for
Quick and Rapid Tongs,
blacksmithing tooling,
accessories, apparel, and
the MZ75 Power Hammer.



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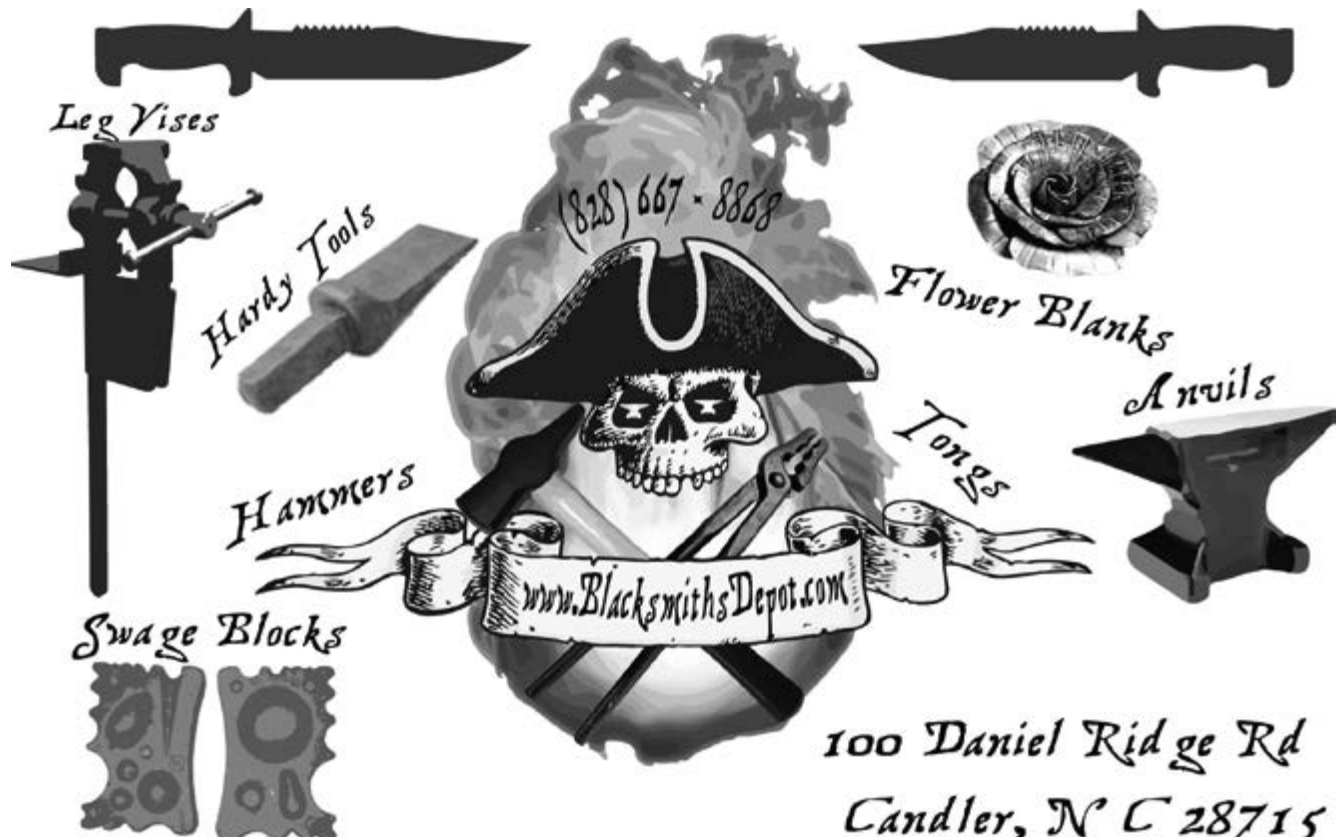
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www.kensiron.com



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SCABA Shop and Swap

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SCABA Shop and Swap



Call to Order Toll Free 24/7 - 866-627-6922

Thank you to our Conference Vendors who graciously donated items for the Conference Auctions!

Their contributions helped to support SCABA. Please consider patronizing these vendors to return the favor!



Reeder Products Inc.

3201 Skylane Drive, Suite 114
Carrollton, Texas 75006 United States
(469) 257-1000

Bill Davis Forge Welded Tomahawk DVD

This DVD is now available to members for a minimal cost (cost of DVD's is minimal to cover reproduction and shipping if applicable.) Contact the SCABA Librarian, Don Garner, if you would like to get a copy of this DVD.

Don Garner: 580-302-1845

(Call or Text. If you get voice mail, Please leave a message.)



For Sale:

Tire Hammer Plans by Clay Spencer

Send a check or money order for \$30 US to Clay Spencer, 73 Penniston Pvt. Drive, Somerville, AL 35670-7013. Or send \$32 US to Paypal.Me/ClaySpencer. E-mail me at clay@otelco.net. PDFs will be e-mailed outside US. Phone 256-558-3658

Beverly shear blades sharpened

Remove your blades and send in USPS small flat rate box with check for \$41 US to 73 Penniston Pvt. Drive, Somerville, AL 35670-7103.

For Sale: I have numerous old tools and collectible items of various kinds including blacksmith related tools and equipment. Too many tools to list them all. Inventory is always changing. Contact: Craig Guy (SCABA Member), Piedmont, OK
Cell Phone: 405-630-7769 (Call or Text)

SCABA Shop and Swap

SCABA Library DVD's Available:

This is a partial list of the DVD titles available to members from the SCABA Library. Contact the Librarian (Don Garner) if you would like to obtain a copy of any listed title or if you have questions on any other titles that may be available. Additional titles are listed on the website. DVD's are available for a very minimal cost to offset the blank disc and cases or sleeves. Shipping cost applies if you need these delivered by mail.

- Robb Gunter Basic Blacksmithing parts 1,2,3 and the controlled hand forging series
- Clay Spencer SCABA conf.2013 pts. 1,2 and 3
- Jerry Darnell 18th century lighting, door latches and hinges
- Brent Baily SCABA conf. 2011
- Mark Aspery SCABA conf. 2011
- Robb Gunter SCABA conf. 1998
- Robb, Brad and Chad Gunter 2009 joinery, forging, repousse, scrollwork, etc.
- Bill Bastas SCABA 2002 pts. 1 - 6
- Jim Keith SCABA conf.2007
- Power hammer forging with Clifton Ralph pts. 1 - 5
- Doug Merkel SCABA 2001
- Bob Alexander SCABA 2008
- A. Finn SCABA 2008
- Bob Patrick SCABA 2004
- Gordon Williams SCABA 2010
- Daryl Nelson SCABA 2010
- Jim and Kathleen Poor SCABA 2001
- Ed and Brian Brazeal SCABA 2006
- Ray Kirk Knives SCABA 2002
- Frank Turley SCABA 1997
- Frank Turley SCABA 2003
- Bill Epps SCABA 2003
- M. Hamburger SCABA 2007

Librarian: Don Garner 580-302-1845 (Cell)
Call or Text. If you get voice mail, please leave a message.

Have an Item for Sale? Item Wanted?

If you have any items that are appropriate for Blacksmiths that you would like to list in the Shop and Swap section (or items you are looking for), please send me your description, contact info, and any photos that you have.

SCABA Swage Blocks

**** (NOTICE: Price Change) ****

\$250.00 plus shipping.
(Same price to members and non-members.)



SCABA Floor Cones



\$275.00 plus shipping.

(Same price to members and non-members.)

To order swage blocks or cones, contact our distributor:

**Nolan Walker at
Nature Farms Farrier
Supply in Norman,
OK.**

405-307-8031

SCABA Shop and Swap

Club Coal:

**** (NOTICE: Price Change) ****

Saltfork Craftsmen has coal for sale. Coal is in 1-2" size pieces. The coal is \$300.00/ton or .15 /pound to members.

No sales to non-members.

NW Region coal pile located in Douglas, OK. If you make arrangements well in advance, Tom Nelson can load your truck or trailer with his skid steer loader for a fee of \$10 to be paid directly to Tom. Tom has moved his skid steer and must now haul the loader to the coal pile to load you out, hence the \$10 charge. You may opt to load your own coal without using Tom's loader. The coal can be weighed out at the Douglas Coop Elevator scales. Contact Tom Nelson (580-862-7691) to make arrangements to pick up a load. Do not call Tom after 9 PM!! Bring your own containers and shovels. Payment for the coal (\$.15 per pound) should be made directly to the Saltfork Treasurer.

NW Region Coal Pile in Thomas:

Don Garner now has a new pile of club coal available for sales to SCABA members. The shop is at 23713 E 860 Rd in Thomas, OK. (One mile west, then one mile north of Thomas.) Contact Don at 580-302-1845 (Cell Phone) to arrange details for purchases.

NE Region coal location:

****NOTICE:****

Charlie McGee is no longer hosting the coal pile in the NE region. If you would be interested in hosting a location in NE, let one of the SCABA Board members know.

S/C region coal location: Club coal is now available at Norman at Byron Doner's place. Call Byron to make arrangements to come by and get coal.

SCABA T-Shirts!

2018 Saltfork Collector T-shirts are available with the 2018 Conference Logo. \$5.00 (plus shipping if applicable.) Contact Josh Perkins to check sizes and quantities that are still available.



Legacy SCABA T-shirts and long sleeve denim shirts are also available on clearance while supplies last. T-Shirts are \$5.00 and Denim Shirts are \$10.00. (Plus shipping if applicable.) Contact Josh Perkins to check sizes and quantities that are still available.

If you would like to purchase shirts, contact Josh Perkins (918) 269-3523.



Have an Item for Sale? Item Wanted?

If you have any items that are appropriate for Blacksmiths that you would like to list in the Shop and Swap section (or items you are looking for), please send me your description, contact info, and any photos that you have.



SCABA Membership Application

For Annual Membership

(Please Print Clearly!)

Date _____

New Member _____

Renewal _____

First Name _____ Last Name _____

Married? _____ Yes _____ No _____ Spouse's Name _____

Address _____

City _____ State _____ Zip _____

Phone (Best Number to Contact) (_____) _____

e-mail _____

ABANA Member? _____ Yes _____ No _____

Newsletter Preference:

☐ No Print Copy

☐ E-mail Alerts for New Newsletters

I have enclosed \$30.00 for dues for one year membership from the date of acceptance.

Signed: _____

Return to: Saltfork Craftsmen, 6520 Alameda, Norman, OK 73026

Note: Registration online by Paypal OR credit card is available from the website.

www.saltforkcraftsmen.org

You do NOT need a Paypal account to use your credit card and registration/renewal is immediate.



Saltfork Regional Meeting Hosting Form

Region: _____ NE _____ SE _____ SW _____ NW

Date: Month _____ Day _____ Year _____

Name: _____

Meeting Address: _____

Host Phone (Best Number to Contact) (_____) _____

Host e-mail _____

Trade Item: _____

Lunch Provided: _____ Yes _____ No

Please provide detailed directions and/or a map to meeting location if possible. Meetings are scheduled on a first come basis.

Return to: Saltfork Craftsmen Regional Meeting Coordinator, Russell Bartling

70 N 160th W Ave

Sand Springs, OK 74063

You can also send the information in an e-mail or text or fill out the online form available on the website in the top banner of the Calendar Tab: www.saltforkcraftsmen.org/Calendar.shtm

Saltfork Craftsmen Artist Blacksmith Assoc. Inc.
6520 Alameda
Norman, OK. 73026

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